

Work Order ID 75070

75070

Page 1

October-17-11 10:48:03 AM

Item ID: D2057 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plug
 Start Date: 17/10/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 28/10/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: ML.5 Date: 11/10/11 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2057	Rev C								

100 Hardinge CNC LATHE SMALL 0.00
100
 Hardinge Memo 0.00
 Hardinge CNC Lathe Small Make as per Dwg D2057 and Folio FA260.

Break all sharp edges 0.015 max.
 Do not drill Ø0.191

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

October-17-11 10:48:03 AM

75070

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Plug

Start Date: 17/10/2011 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 28/10/2011 **Req'd Qty:** 20.00

20

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/
Run Hours[illegible]

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

Due Qty Qty Number Stamp
 3/11/02 (20)

W111022

11-11-07
(20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-17-11 10:48:07 AM

Page 1

Work Order ID: 75070

75070

Parent Item: D2057

D2057

Parent Item Name: Plug

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP D02.08.22Make in CobraKJ

IPP Rev:E 08-05-27 as per ECN1195P DD verified by:EC

IPP Rev:F 08-06-04 Added QC8 JLM Verified By:EC

IPP Rev:G 08-06-20 rev.D as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased		No		100	f	54.1780	0.1	2.105263			
M6061T6R0 750									**			11/10/11	
6061-T6 Round Bar .750"													

Location

Loc Qty

Loc Code

MAT013

54.178

112442

0.796

116406

0.617

117481

2.51

118106

2.255

119231

48

1' 0.541' 0.917' 1.6170

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	75070
Description: Plug		Part Number:	D2057
Inspection Dwg: D2057 Rev: C			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

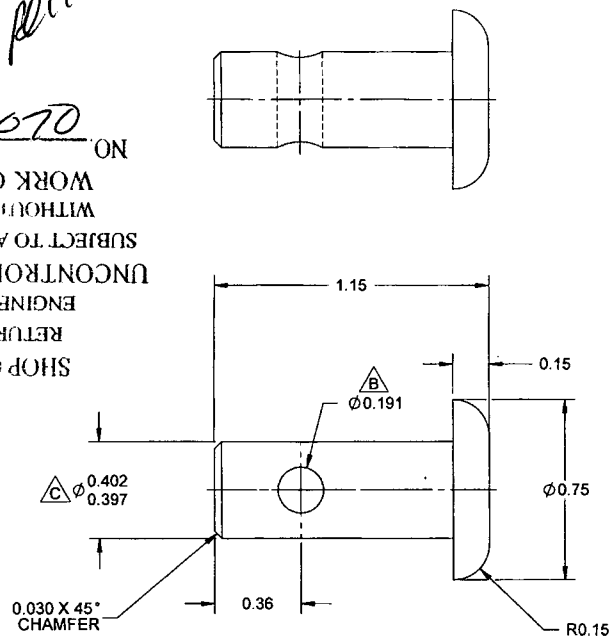
X	First Article	Prototype
---	---------------	-----------

[illegible]

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/10/19	Date:	11/10/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	07.11.26	Dimensions added	KJ/EC/DD	
C	08.07.03	0.397-0.402 dimension revised	KJ/DD	

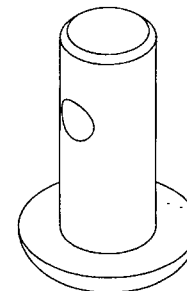
75070
 NO
 WORK ORDER
 WITHOUT NOTICE
 SUBJECT TO AMENDMENT
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY



D2057 PLUG

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs



RELEASED
08 06 10

C	Ø0.402/Ø0.397 WAS Ø0.430/Ø0.425; REASON: ID OF D2010-103/104 DECREASED TO Ø0.402	PH	08.06.10
B	REDRAWN: Ø0.191 WAS Ø0.187 (TSR A1100)	CP	98.10.15
A	NEW ISSUE	JB	92.03.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JB		
CHECKED	JB	DRAWING NO.	REV. C
MFG. APPR.	JB	D2057	SHEET 1 OF 1
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	PLUG	NTS
DATE	08.06.10	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	